

Work Order ID 71918

Wednesday, July 13, 2011 12:45:47 PM



Page 1

Item ID: D3281-4L02

Accept



Setup Start



Revision ID:

Item Name: Floor Protector, Aft RH (Black)

Stop



Start Date: 7/13/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: *MF*

Date: 11-07-13 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description
--------------------------------	--------------------------

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3281 Rev F

DSI 9504 A

100 0.00

	HAND FINISHING THERMOFORMING
--	------------------------------

Thermoform	Memo	0.00
------------	------	------

Thermoforming Machine	Cut Blanks
-----------------------	------------

105 0.00

	Dry Material
--	--------------

HandThermo	Memo	0.00
------------	------	------

Hand Finishing Thermoforming	Dry Sheet as per QSI022 POLYCARBONATE
------------------------------	---------------------------------------

Temp: 340° FTime IN: 4:30 pmTime OUT: 7:00 am11/07/1411/07/15*x5**DL*
*11/07/15**x5**DL*
11/07/15

W/O:		WORK ORDER CHANGES					
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Page 2

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Accept



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Start Date: 7/13/2011 Start Qty: 5.00



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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID**

110

**Operation
Description**Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Thermoform

THERMOFORMING MACHINE

0.00

Thermoforming Machine

Memo

0.00

Thermoform as per Dwg. D3281 and Folio FTA 010
Dwg. Rev. F
Folio Rev. D

X9

SL
11/07/15

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

X5

SL
11/07/15

130



HAND FINISHING THERMOFORMING

0.00

Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions

X5

SL
11/07/15

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Item Name: Floor Protector, Aft RH (Black)

Start Date: 7/13/2011 Start Qty: 5.00

Required Date: 7/20/2011 Req'd Qty: 5.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140



QC2- Inspect parts off machine FAI/FAIB

0.00

x5

QC

Memo

0.00

6h
11/07/16

Quality Control

150



QC5- Inspect part completeness to step on W/O

0.00

W 11 07 20(5)

QC

Memo

0.00

Quality Control

160



Packaging

0.00

11/07/21 QD SP

Packaging

Memo

0.00

Packaging

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Picklist Print

Wednesday, July 13, 2011 12:45:44 PM

Page 1

Work Order ID: 71918



Parent Item: D3281-4L02



Parent Item Name: Floor Protector, Aft RH (Black)

Start Date: 7/13/2011

Required Date: 7/20/2011

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP Rev:A 04.07.01 'New issue! KJ/JLM

IPP Rev B 07.08.07 Thermoform in house DL

IPP Rev. C

ADD Step 105 Dry Material 10/04/21 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-02		Purchased	No				sf	771.9516		21.665			

MLEXS.093-F6006-02



GE PLASTICS LEXAN SHEET

Location	Loc Qty	Loc Code
therm	771.95158	
106751	105.89	
10877	666.06158	

106751
10877

771.95158

105.89

666.06158

21.665 sq ft

DH
11/07/18.

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD	Work Order:	71918
Description: Floor Protector, Aft RH	Part Number:	D3281-4
Inspection Dwg: D3281 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than .1875"	✓			
Shape Definition	✓			
Texture Retention	—			
Material imperfections such as bumps, cracks, voids, scratching	—			

Measured by:

Date: 11/07/15

TRIMMING SECTION

Measured by:

Date: 11/07/18

Audited by:

Date: 11/07/19

Preliminary Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	
C	10.09.01	Dimensions updated per Dwg Rev E	KJ	
D	11.06.21	Dwg Rev updated	KJ	

W/O:

WORK ORDER CHANGES

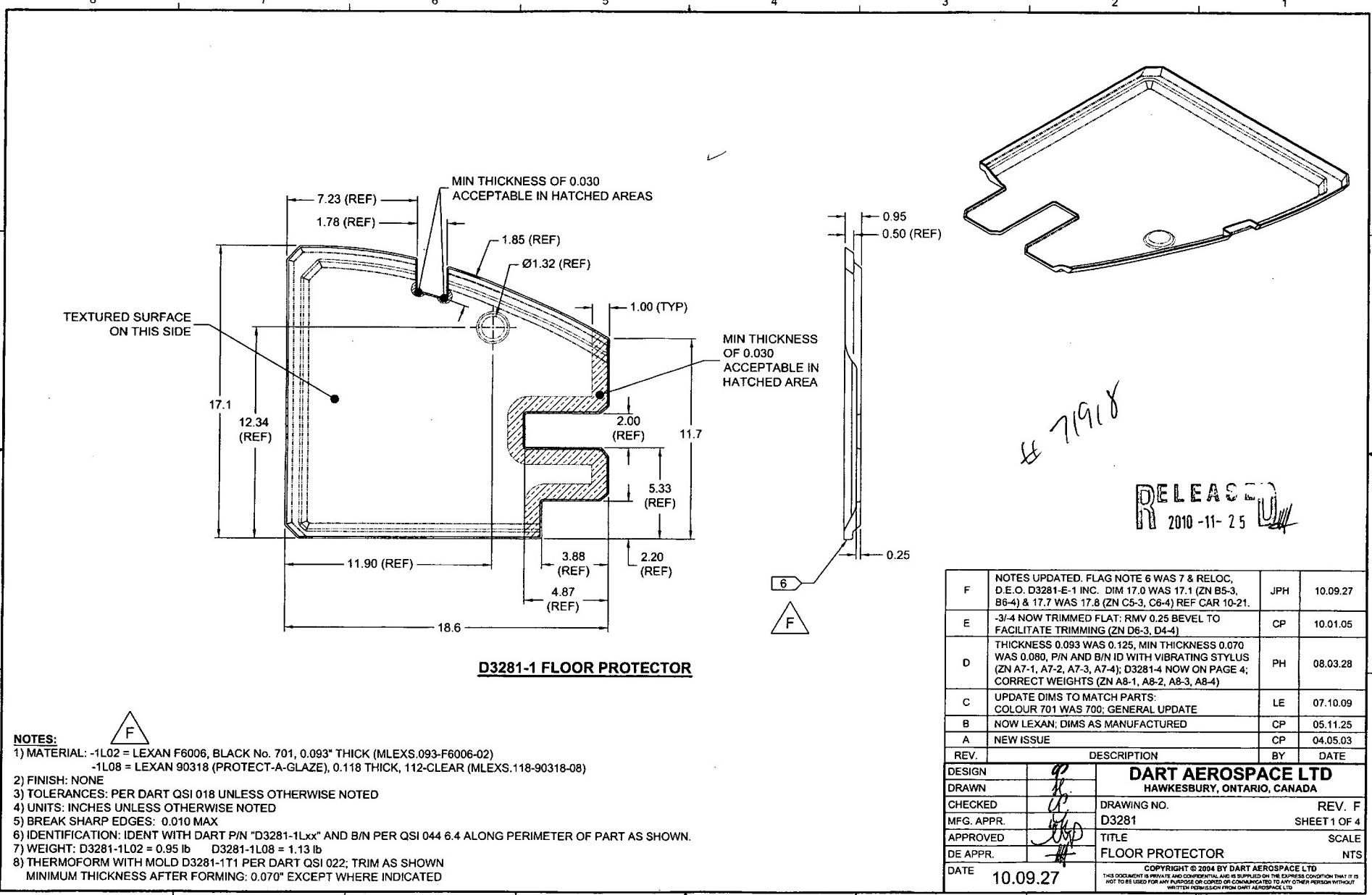
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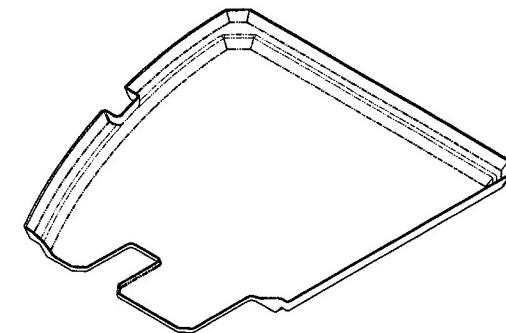
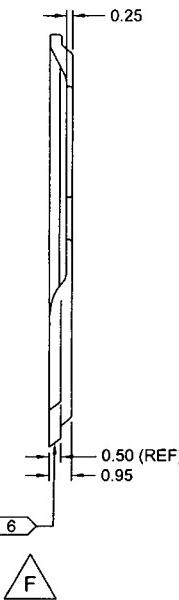
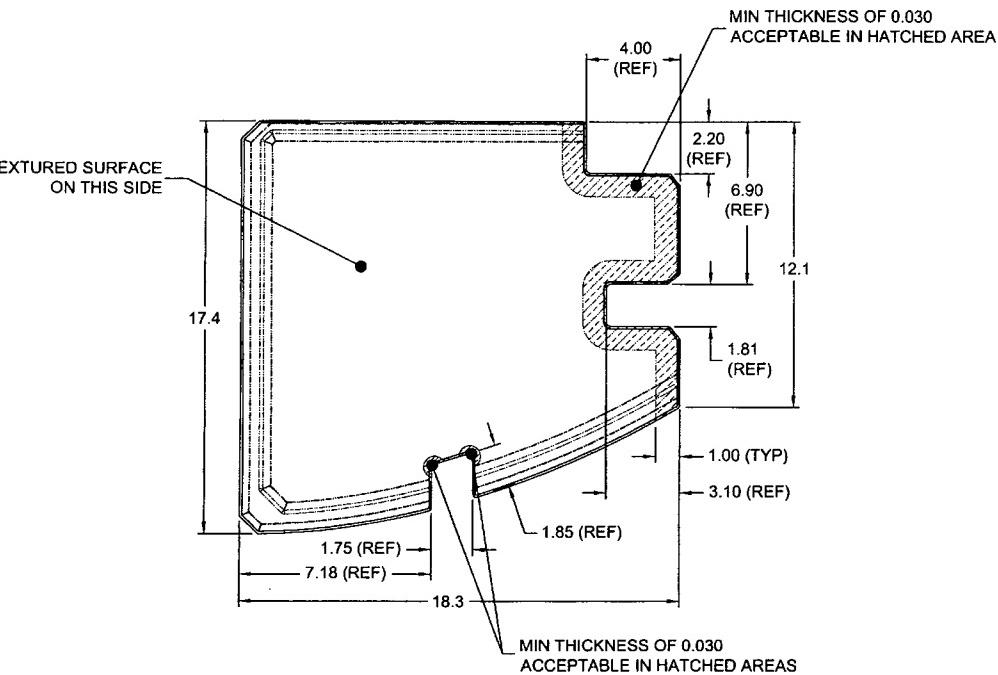
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8 7 6 5 4 3 2 1

D



71918

D3281-2 FLOOR PROTECTOR


NOTES:

- 1) MATERIAL: -2L02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)
-2L08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 MAX
- 6) IDENTIFICATION: IDENT WITH DART P/N "D3281-2Lxx" AND B/N PER QSI 044 6.4 ALONG PERIMETER OF PART AS SHOWN.
- 7) WEIGHT: D3281-2L02 = 0.95 lb D3281-2L08 = 1.13 lb
- 8) THERMOFORM WITH MOLD D3281-2T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED

8 7 6 5 4 3 2 1

DESIGN	90	DART AEROSPACE LTD	
DRAWN	10	HAWKESBURY, ONTARIO, CANADA	
CHECKED	10	REV. F	
MFG. APPR.	10	DRAWING NO. D3281	
APPROVED	10	SHEET 2 OF 4	
DE APPR.	10	TITLE FLOOR PROTECTOR	
DATE	10.09.27	SCALE	NTS

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A

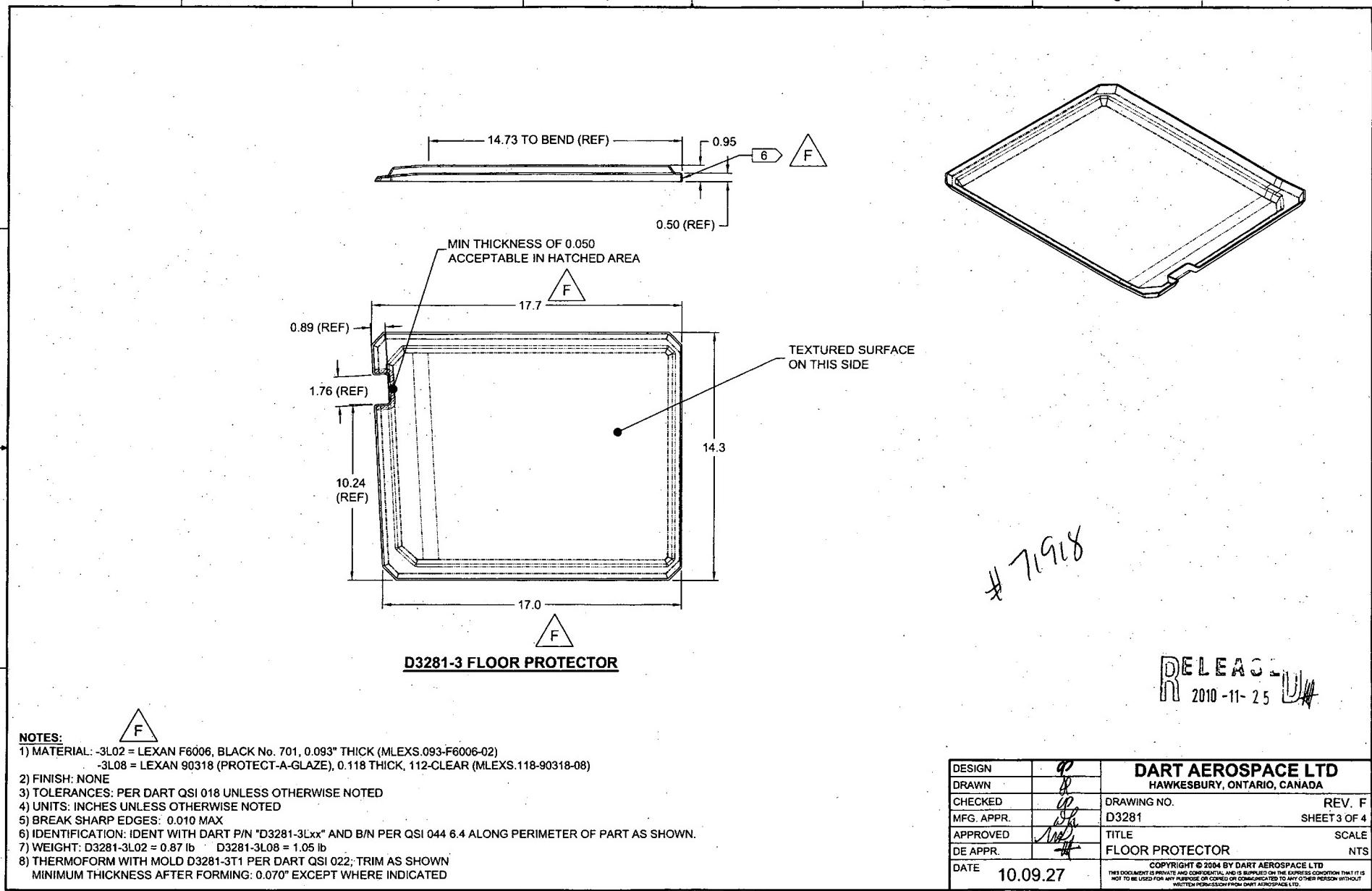
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8 7 6 5 4 3 2 1



DESIGN	Q2	DART AEROSPACE LTD
DRAWN	10	HAWKESBURY, ONTARIO, CANADA
CHECKED	10	DRAWING NO. REV. F
MFG. APPR.	10	D3281 SHEET 3 OF 4
APPROVED	10	TITLE SCALE
DE APPR.	10	FLOOR PROTECTOR NTS
DATE	10.09.27	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8 7 6 5 4 3 2 1

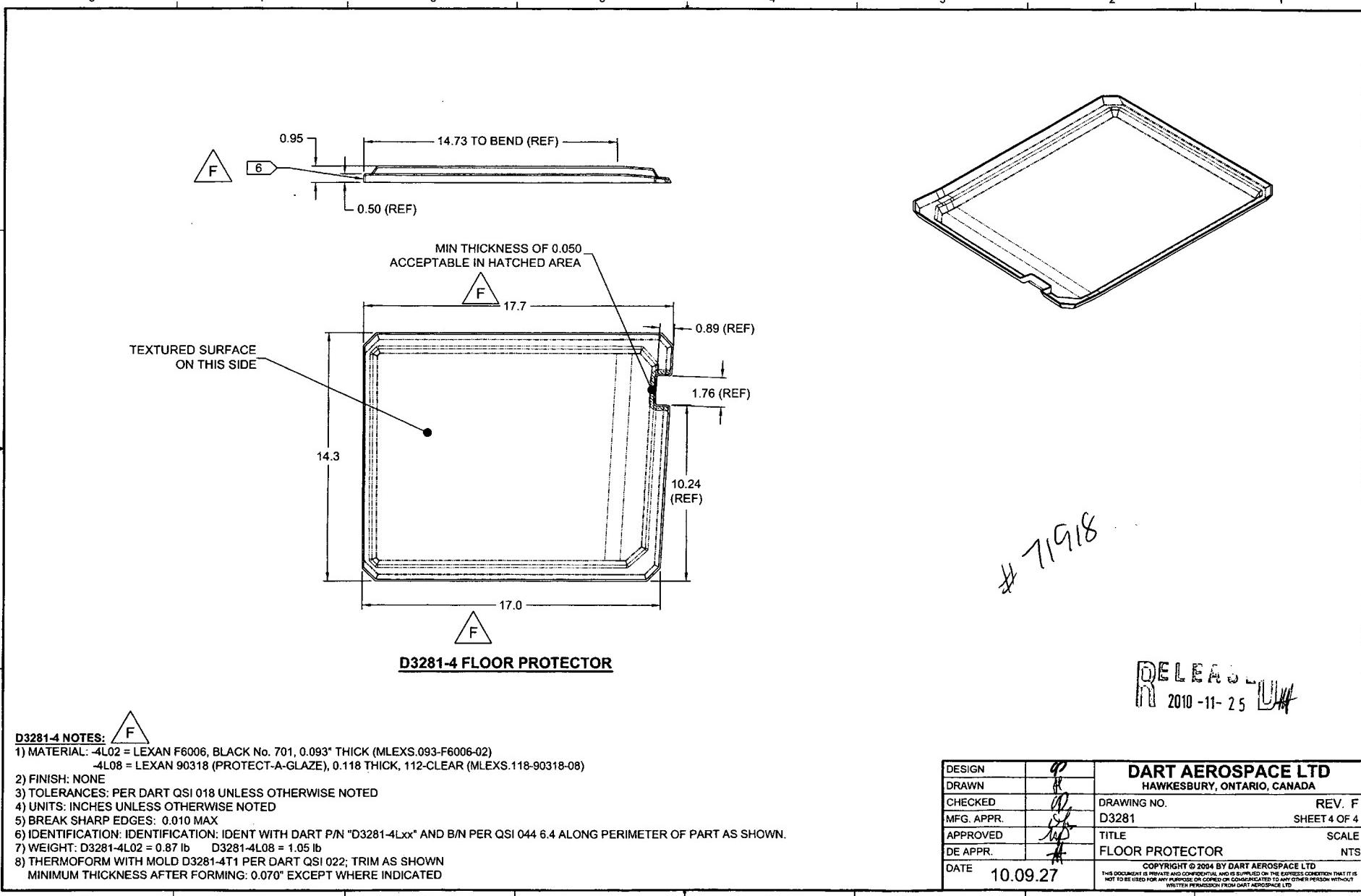
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